

Work Order ID 75324

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75324

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Item ID: D206-628-021 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step LH
 Start Date: 20/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-628	G								

100 DOCUMENT CONTROL 0.00
100
 DC Memo 0.00
 Document Control Photocopy blue file and type labels as per PPP D206-628-021 CHG 003 *Sulu* *MLJ 11-11-11*

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging *MLJ*

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.00
 Quality Control *Sulu* *74*
47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries

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Quality Control

Qly
 2010

11/11/15 

11-11-15
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75324

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Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D as per ECN 766 JLM
IPP Rev:E as per ecn 1118 DD verified by:EC IPP Rev:F
11.09.15 added NAS1149D0463J DD verf by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A *AN4-14A* Bolt		Purchased	No			120	Each	263.0000	4	16			
-------------------------------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST357	263	
118628	100	
118706	63	
119127	100	

AN4-15A *AN4-15A* Bolt		Purchased	No			120	Each	567.0000	8	32			
-------------------------------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST358	567	
118112	4	
118648	263	
118706	200	
119127	100	

D2724-041 *D2724-041* 206L Step Assembly		Manufactured	No			120	Each	0.0000	1	4			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2731-7 *D2731-7* Mounting Lug		Manufactured	No			120	Each	48.0000	4	16			
---	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST468A	48	
71860	48	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2732-030

Manufactured No

120

Each

4.0000

8

32

D2732-030

Rubber Cushion

**

Handwritten: 370987

Location

Loc Qty

Loc Code

ST409

4

56515

0

64283

4

Manufactured No

120

Each

21.0000

D3394-043

D3394-043

Lug Assembly

**

Handwritten: 37493

Location

Loc Qty

Loc Code

ST475

21

62930

1

66429

20

Purchased No

120

Each

13,966.00

MS21042L4

MS21042L4

Nut

**

Handwritten: 48

Location

Loc Qty

Loc Code

ST300

2966

117441

51

117601

537

118451

1378

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-628-021

Parent Item Name: Heli-Access-Step LH

75324

D206-628-021

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

120

Each

16,603.00

12

48

**

NAS1149D0463.I

Washer

Location

Loc Qty

Loc Code

ST298

603

116025

16

116805

0

117291

1

117460

2

118179

43

118384

297

118612

244

ST302

1000

119042

1000

ST407

15000

119075

10000

119097

5000

78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

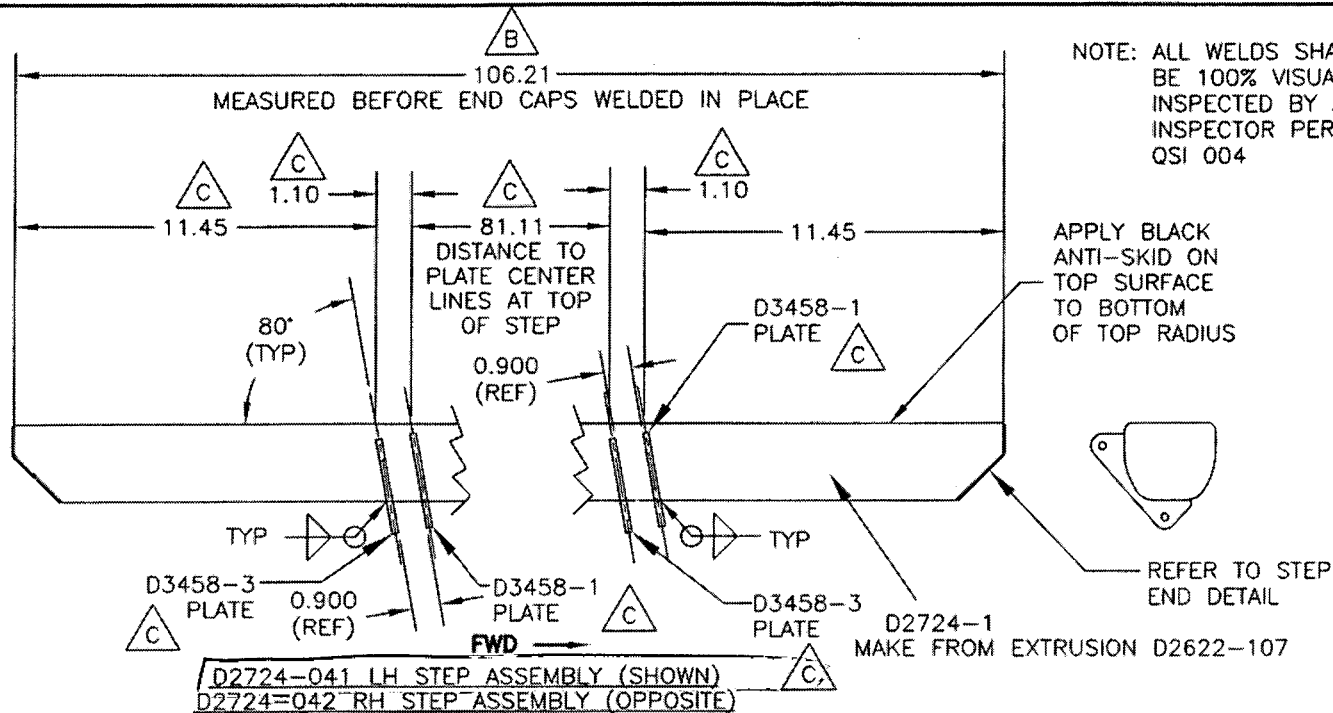
5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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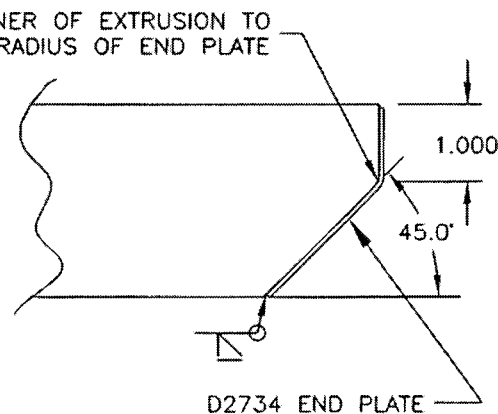


D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TYPICAL STEP END DETAIL
NOT TO SCALE

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

RELEASED
05.11.14

DART
REFERENCE ONLY

DESIGN	DRAWN BY	DATE	TITLE	SCALE
KE	PH	05.09.19	D2724	NTS
CHECKED	APPROVED	05.09.19	206L/407 STEP ASSEMBLY	
A		97.12.04	NEW ISSUE	
B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C		05.09.19	RE-DESIGN, ADD D3458-1/-3	

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. C
SHEET 1 OF 1

